

Work Order ID 166355

Monday, September 18, 2017 8:53:13 AM

166355

Page 1

Item ID: D500-560-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cargo Mirror Installation 6"
 Start Date: 9/18/2017 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 9/22/2017 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: **DAS 21 9-89** Date: **SEP 18 2017** Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
D500-560	Rev D	SEP 17 2017 <i>sep</i>

100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels as per PPP D500-560-041 CHG006								

110	Small Fab	0.00							
110									
Small Fab	Memo	0.55							
Small Fab	Before assembly repass tap on stud. Assemble as per drawing D500-560 PAGE 8- BLUE FILE								

120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.04							
Quality Control									

2 **DAS 28 9-89** **SEP 21 2017** **DAS 36 9-89**

2X **DAS 27 9-89** **17/09/19** **DAS 35 9-89** **SEP 19 2017**

2 **DAS 27 9-89** **SEP 20 2017** **DAS 34 9-89**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
		OTHER : ☐							

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130

Pick Kit

0.00

130

Packaging

Memo

0.02

Packaging

2

SEP 18 2017

Insp. Stamp

DAS
27
9-89

140

QC4- 100% Inspect kits for completeness

0.00

140

QC

Memo

0.06

Quality Control

2 0

SEP 20 2017

DAS
9
9-89

150

Identify as per dwg & Stock Location: _____

0.00

150

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D500-560-041
LOCATION: FG011

2

DAS
28
9-89

SEP 21 2017

DQA: _____ Date: _____



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Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : ☐							

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Page 3

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2

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

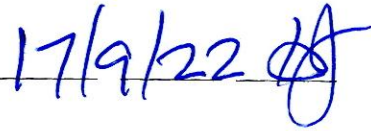
160

QC

Memo

0.20

Quality Control

17/9/22 
SEP 21 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
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Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

Picklist Print

Monday, September 18, 2017 8:53:16 AM

Page 1

Work Order ID: 166355

166355

Parent Item: D500-560-041

D500-560-041

Parent Item Name: Cargo Mirror Installation 6"

Start Date: 9/18/2017

Required Date: 9/22/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:E03.10.15Reformat; Removed D2057KJ/RF
IPP Rev:F 08-05-27 as per ECN1195p DD verified by:EC IPP Rev:G
10.04.22 chg route seq DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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AN526C1032R10

Purchased

No

110

Each

81.0000

4

8

AN526C1032R10

Screw

**

Location

Loc Qty

Loc Code

FP001

1

m135133

1

ST327

80

m137851

80

D1048

Manufactured

No

110

Each

9.0000

2

4

D1048

Clamp

**

Location

Loc Qty

Loc Code

GA

9

148270

1

159855

8

D1049

Manufactured

No

110

Each

6.0000

2

4

D1049

Saddle

**

Location

Loc Qty

Loc Code

GA

6

162358

1

164926

5

SEP 18 2017

SEP 18 2017

SEP 18 2017

DQA: _____ Date: _____



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D500-560-041

Parent Item Name: Cargo Mirror Installation 6"

Start Date: 9/18/2017

Required Date: 9/22/2017

Start Qty: 2.00

Required Qty: 2.00

D2010-101 Manufactured No

110 Each 5.0000 1 2

D2010-101

Mirror Bracket 369/500

**

Location

Loc Qty

Loc Code

ST479

5

148945

1

163530

4

D2010-103 Manufactured No

110 Each 4.0000 1 2

D2010-103

Mirror Arm 369/500

**

Location

Loc Qty

Loc Code

ST351

4

162412

4

D2011-101 Manufactured No

110 Each 40.0000 1 2

D2011-101

Mirror 6"

**

Location

Loc Qty

Loc Code

FG

3

106348

1

158473

2

ST384

37

158473

1

159140

10

160663

26

AN3-4A Purchased No

140 Each 342.0000 4 8

AN3-4A

Bolt

**

Location

Loc Qty

Loc Code

ST350

342

m138260

342

SEP 18 2017

SEP 18 2017

SEP 18 2017

SEP 18 2017

Monday, September 18, 2017 8:53:16 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



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Misidentified ☐	Past Due ☐																																																																

1. INTRODUCTION

The Dart D500-560-041 Cargo Mirror Assembly mounts to the front end of the left-hand skidtube on MD 369/369A/369H/369HM/369HS/369HE/369D/369E/369F/369FF/500N rotorcraft. The mirror provides a clear view of the cargo hook for accurate and safe hookup and release of external loads.

2. GENERAL NOTES

COMPATIBILITY

Compatibility of this installation with the aircraft is the **responsibility of the installer**. Ensure that this installation does not conflict with a previous modification.

WORKMANSHIP

The installation should be completed to the standards and practices of the Aircraft Maintenance Manual.

CONTINUING AIRWORTHINESS

This installation should be maintained in accordance with the Maintenance Manual Supplement **MMS-D500-560**.

3. INSTALLATION PROCEDURE

Install the D500-560-041 Cargo Mirror Assembly on the left-hand skidtube as follows:

1. Remove the 4 bolts securing the front wearplate (see Figure 1).
2. Install the D2010-101 Bracket above the forward wearplate. The bolts should be sealed with Sikaflex-241/-291 or Proseal 890 or MIL-S-8802 Class 'B2' sealant before installing as per Figure 2.
3. Install remaining hardware per Figure 2. Adjust the angle of the D2010-103 Arm and tighten the AN526C1032R10 screws to secure arm.
4. To adjust the mirror: loosen (DO NOT REMOVE) the three adjustment screws shown in Figure 2, reposition the mirror, then tighten the screws.

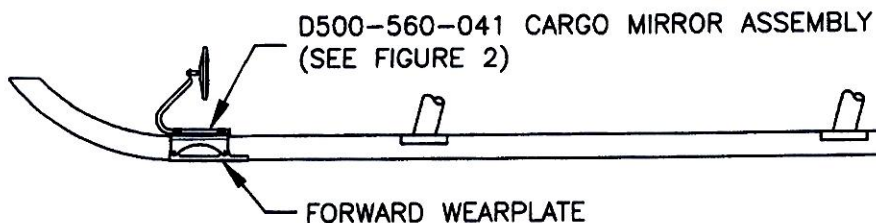


Figure 1: Location of D500-560-041 Cargo Mirror Assembly, LH Skidtube Shown.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 1166311 MCS
1705-18

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Revision: D

Date: 01.04.24

DQA: _____ Date: _____



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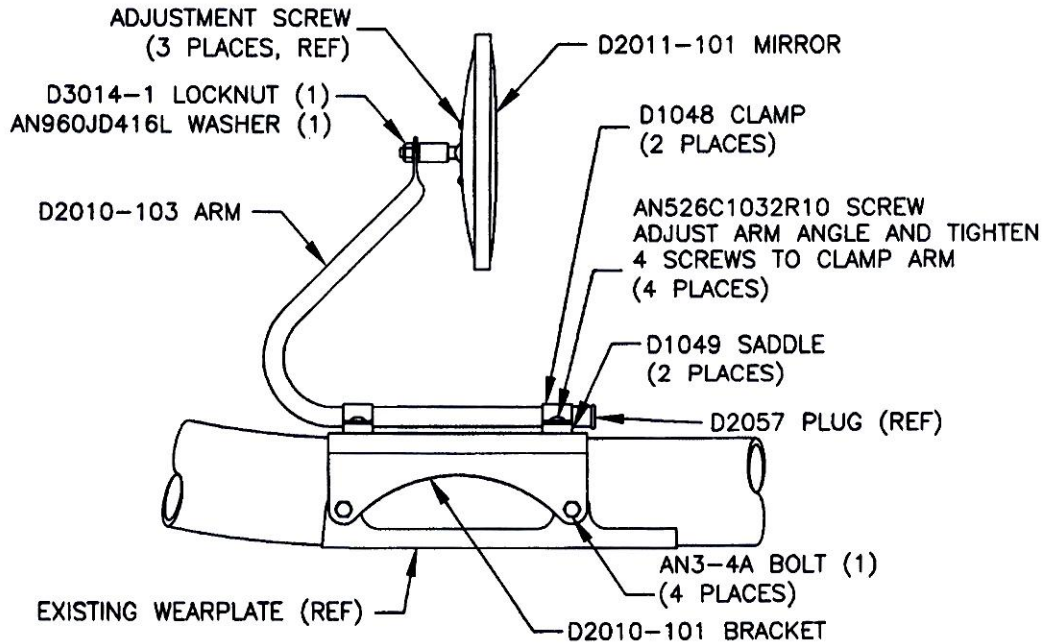


Figure 2: Installation of D500-560-041 Cargo Mirror Assembly

4. WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D500-560-041 Cargo Mirror Assembly	1.0 lb 0.45 kg	-45 in -1.14 m	-45 lb-kg -0.51 m-kg	24 in 0.61 m	24 in-lb 0.27 m-kg

5. PARTS LIST

Qty	Part Number	Description
X	D500-560-041	CARGO MIRROR ASSEMBLY
1	D2011-101	MIRROR
1	*D3014-1	LOCKNUT
1	*AN960JD416L	WASHER
2	D1048	CLAMP
2	D1049	SADDLE
1	D2010-101	BRACKET
1	D2010-103	ARM
4	AN3-4A	BOLT
4	AN526C1032R10	SCREW (OR AN526-1032R10)

* PARTS ARE INCLUDED WITH D2011-101 MIRROR

Work Order ID 166355***166355***

Page 1

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Accept

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Stop ***NS2***

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Start Date: 9/18/2017 Start Qty: 2.00

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Cust Item ID:

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Approvals: Process Plan: 21 Date: SEP 18 2017 Tooling: _____ Date: _____
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Draw Nbr	Revision Nbr	
D500-560	Rev D	SEP 17 2017 <i>ref</i>

100 Document Control 0.00
100 DOCUMENT CONTROL
DC Memo 0.00
Doc.Control -USB or Paperwork Photocopy bluefile and create labels as per PPP D500-560-041 CHG006

2 SEP 20 2017 DAS 5 9-89
DAS 36 9-89

110 Small Fab 0.00
110
Small Fab Memo 0.55
Small Fab Before assembly repass tap on stud.
Assemble as per drawing D500-560
PAGE 8- BLUE FILE

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DAS 27 9-89
SEP 19 2017

120 QC5- Inspect part completeness to step on W/O 0.00
120
QC Memo 0.04
Quality Control

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Department of Transport

Supplemental Type Certificate

This approval is issued to:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ontario
K6A 1K7 Canada

Number: SH90-17

Issue No.: 7

Approval Date: June 7, 1990

Issue Date: April 25, 2001

Responsible Office:

Ontario

Aircraft/Engine Type or Model:

Mcdonnell Douglas HC 369, 369A, 369D, 369E, 369F, 369FF,
369H, 369HE, 369HM, 369HS, 500N, 600N

Canadian Type Certificate or Equivalent:

H-95 (H3WE)

Description of Type Design Change:

Utility Equipment Installation

Installation/Operating Data,
Required Equipment and Limitations:

Installation is to be carried out in accordance with Dart Aerospace Master Document List Drawing No. D500-583, Rev G, dated 01.04.24, or later Transport Canada approved revision.

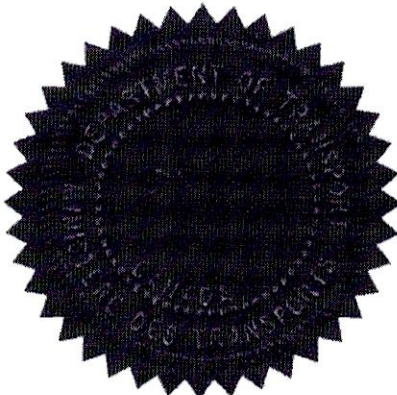
Limitations

Bearpaws, if installed, must be installed as a pair (left and right).

Required Equipment

Bearpaws → Maintenance in accordance with Dart Aerospace Instructions for Continued Airworthiness ICA-D500-572, Rev 0, dated 01.02.21, or later Transport Canada accepted revision.

Mirror Installation → Maintenance to be in accordance with Maintenance Manual Supplement MMS-D500-560, Rev C., dated March 10th, 1993, or later Transport Canada accepted revision.



Conditions: This approval is only applicable to the type/model of aeronautical product specified therein. Prior to incorporating this modification, the installer shall establish that the interrelationship between this change and any other modification(s) incorporated **will not** adversely affect the airworthiness of the modified product.

Alex Pompei
For Minister of Transport